

Date: Thursday, 19/03/2009 4:30:35 PM  
 User: Julie Dawson

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	46607			
Estimate Number	10310			
P.O. Number	:		Part Number	: D26175
This Issue	19/03/2009	S.O. No. :	Drawing Number	: D2617 REV D2
Prsht Rev.	NC		Project Number	: N/A
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	: D2
Previous Run	45663		Material	:
Written By	:		Due Date	: 23/03/2009
Checked & Approved By	JUL 09.03.14		Qty:	100
Comment	Um: Each Est H 04.07.14 Reformat; added step 5 KJ/JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0500W058	6061-T6 RD Tube .500 x.058W	
		Comment: Qty.: 0.0205 f(s)/Unit Total : 2.0475 f(s) 6061-T6 Round Bar 1.5" Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall M6061T6T0.500W.058) Batch 1110335	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL	
		1-Machine as per Folio FA438 and Dwg D2617	
		2-Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 46607

Part Number: D26175

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



100

Comment: INSPECT ALODINE

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST39

AS 09/03/24 (100)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



09/03/24 AS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	410607
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617	Rev: D2	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

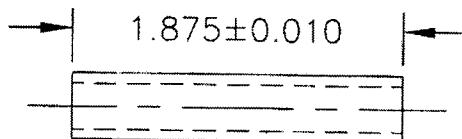
Measured by:	<u>JK</u>	Audited by:	<u>J-F</u>	Prototype Approval:	N/A
Date:	09/03/21	Date:	09/03/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	
B	06.03.08	Dwg Rev change	KJ/JLM	
C	08.01.16	Tolerance revised for 0.500 dimension	KJ/EC/DDC	

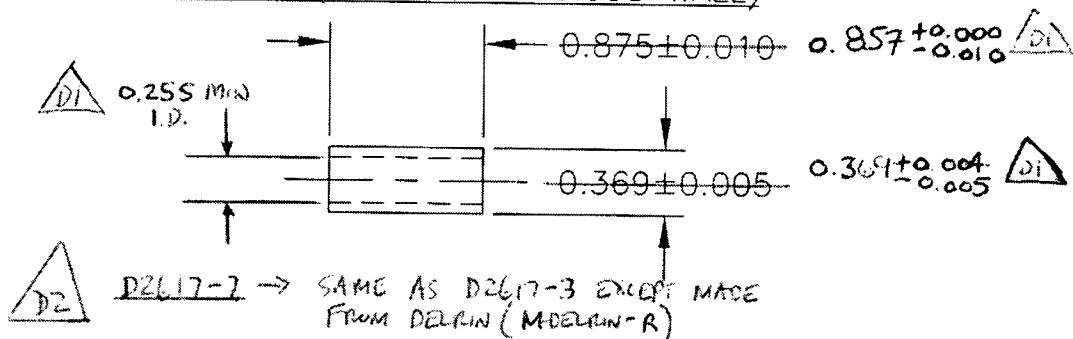


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2617
DATE	01.07.04			REV. D SHEET 1 OF 1
				SCALE 1:1
DL	04.04.10 #1P	ADD D2617-7	A	96.10.08 NEW ISSUE
			B	97.05.08 .875 WAS 1.125
			C	97.06.04 0.369 DIA WAS 0.375
			D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
			DI	1P-# 04.07.12 CORRECT TOLERANCE (CNR 779)

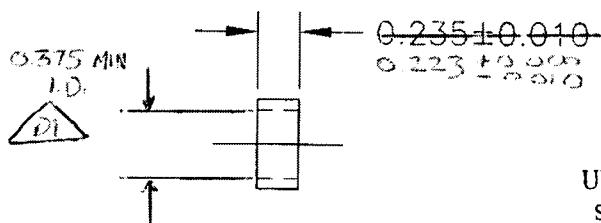
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05 #1P

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
44660

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4) OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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